



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3319-3

Job Sheet 200284



Part No: D3319-3

Job Qty: 12 pcs 8

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/24/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER
DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		10/14/19	0.17	2.80	Waterjet - Flow		02/19/10/15
110	QC 2	12 pcs		10/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		02/19/10/15
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

ART

ROSPACE

Order No: S222710



3319-3
200284

Order/ Batch: S222710

D

Products: Various STC's

Date: 11/19/19

DART Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

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Container No: S222710



Part: D3319-3

Job No: 200284

Serial No/Batch: S222710

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/19/19

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120 QC 8	12 pcs	10/14/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
140 Small Fab - Brake NC - B4B	12 pcs	10/14/19	0.25 0.80	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	12 pcs	10/14/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Automated Welding - B4B	12 pcs	10/14/19	0.00 3.82	Automated Welding - 1 - B4B	
170 QC 10	12 pcs	10/14/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	

OCT 17 2019
DAS 40
9-89

OCT 22 2019
DAS 30
9-89

OCT 22 2019
DAS 68
9-89

ML

180 QC 5	12 pcs	10/14/19	0.00 0.00	QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	CL
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	CL
190 Spray Paint - 2 - B4B	12 pcs	10/14/19	0.00 1.20	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	RD 19-11-19
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 3	12 pcs	10/14/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
210 Packaging 3-1 - Stock - B4B	12 pcs	10/14/19	0.00 0.00	QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

220 QC 21 - SA

12
pcs

10/14/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 53

DAS
21
9-20

DEC 02 2019

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

140 - Form using DT8326 & DT8261 as per Dwg D3319

150 - (QC5- Inspect part completeness to step on W/O)

160 - 8259 Hardcoat Rod M/59025

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.

BATCH: 5227557

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____) Identify on inside surface using a permanent fine point marker with the following:

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	39 sf (3.25 ea)	100-Waterjet - Flow - 1	<u>SX15102</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	39	125	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches	+ 0.005 - 0.001	0.195 0.189	
2	Wearplate	0.500inches	+ 0.006 - 0.001	0.506 0.499	
3	Wearplate	0.316inches	± 0.010	0.326 0.306	
4	Wearplate	0.607inches	± 0.010	0.617 0.597	
5	Wearplate	2.940inches	± 0.030	2.970 2.910	
6	Wearplate	2.690inches	± 0.030	2.720 2.660	
7	Wearplate	3.527inches	± 0.010	3.537 3.517	
8	Wearplate	4.520inches	± 0.030	4.550 4.490	
9	Wearplate	5.063inches	± 0.010	5.073 5.053	
10	Wearplate	6.160inches	± 0.030	6.190 6.130	
11	Wearplate	0.600inches	± 0.030	0.630 0.570	
12	Wearplate	8.690inches	± 0.010	8.700 8.680	
13	Wearplate	30.790inches	± 0.010	30.800 30.780	
14	Wearplate	52.880inches	± 0.030	52.910 52.850	
15	Wearplate	62.770inches	± 0.010	62.780 62.760	
16	Wearplate	74.420inches	± 0.010	74.430 74.410	
17	Wearplate	75.520inches	± 0.030	75.550 75.490	
18	Wearplate	0.050inches	± 0.010	0.060 0.040	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S222710



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